

Date: Monday, 4/10/2006 11:13:50 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR SUPPORT
Job Number	: 26611		
Estimate Number	: 12309		
P.O. Number	: N/A	Part Number	: D3471043
This Issue	: 4/10/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3471 REV.A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26268	Drawing Revision	: A
		Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 4/28/2006
Checked & Approved By	: <u>06.04.10</u>	Qty:	1 Um: Each
Comment	: est rev A 06.03.02 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MS3584216	CLAMP
-----	-----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:

Qty	Part number	Description	Batch	
1	MS35842-16	CLAMP	M100261	1A

PTO

2.0	MS20427M44	RIVET
-----	------------	-------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 pick:

Qty	Part number	Description	Batch	
3	MS20427M4-4	Rivet	M100261	1A

10

3.0	D34713	SUPPORT
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:

Qty	Part number	Description	Batch	
1	D3471-3	Support	B26126	

10

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3471

10

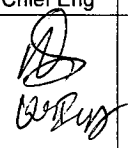
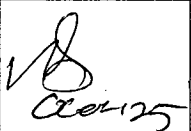

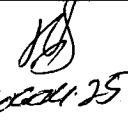
FF 06.04.27

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr		Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
Step 06.04.26	4	one clamp screwp		destroy & replace	FF 06.04.26			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:13:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26611

Part Number: D3471043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

120604/27 (10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

120604/27 (10)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

120604/28 (10)

Job Completion



u 06.04.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

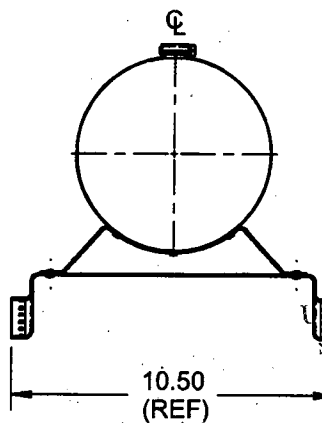
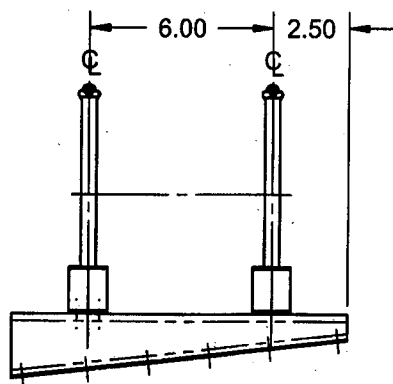
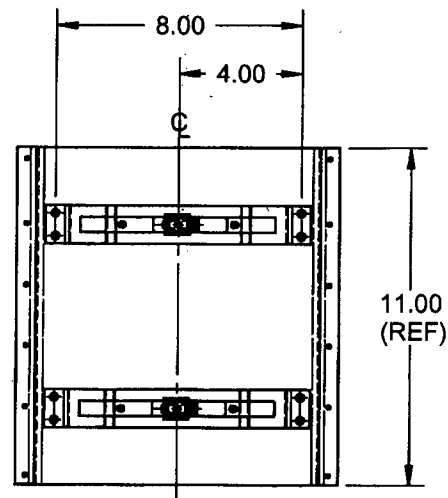
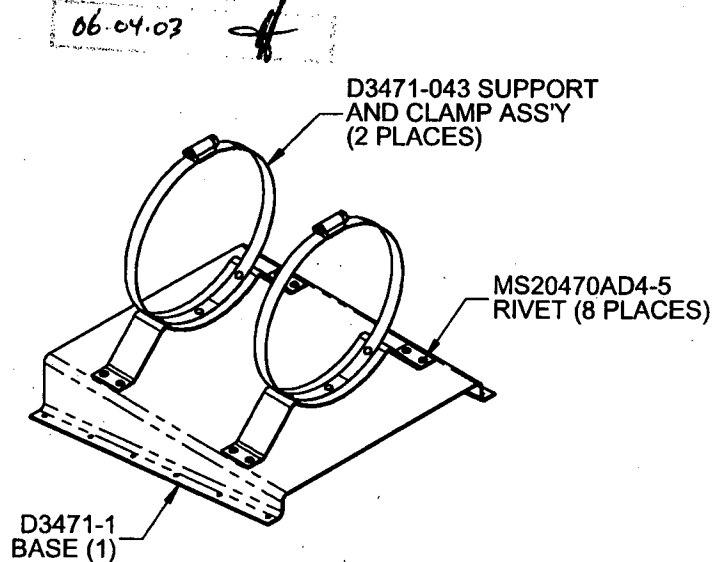
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3471	REV. A SHEET 1 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:6
A	05.12.21	NEW ISSUE	



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NO 26611

D3471-041 BLOWER MOTOR SUPPORT

NOTES:

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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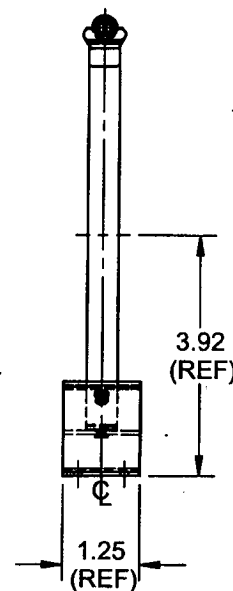
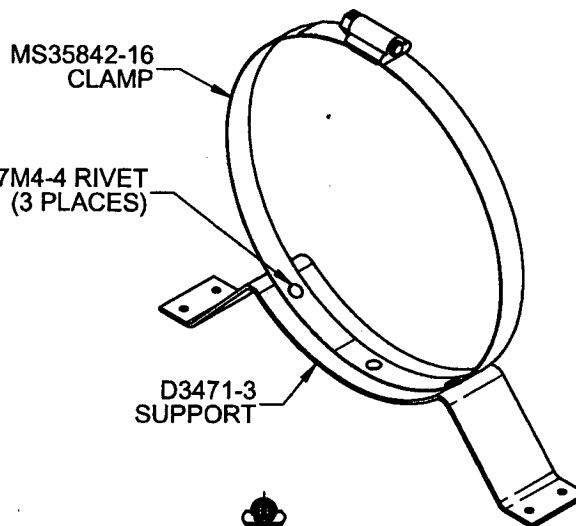
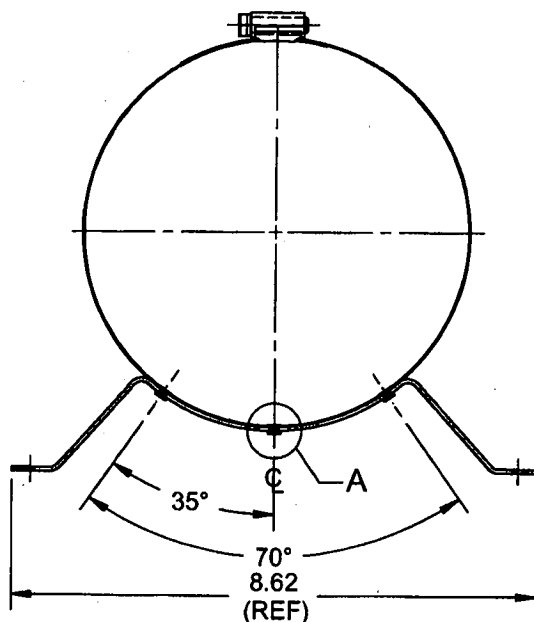
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CHECKED H	APPROVED H	DRAWING NO. D3471	REV. A SHEET 2 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:3

06.04.03

LOCATE AND TRANSFER DRILL
#30 ($\varnothing 0.129$) THRU HOLE FROM
D3471-3 TO MS35842-16 CLAMP
AND C'SINK $\varnothing 0.230 \times 100^\circ$
(3 PLACES)



DETAIL A: COUNTERSINK HOLES
(RIVET NOT SHOWN FOR CLARITY)
SCALE 1:1



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D3471-043 SUPPORT & CLAMP ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

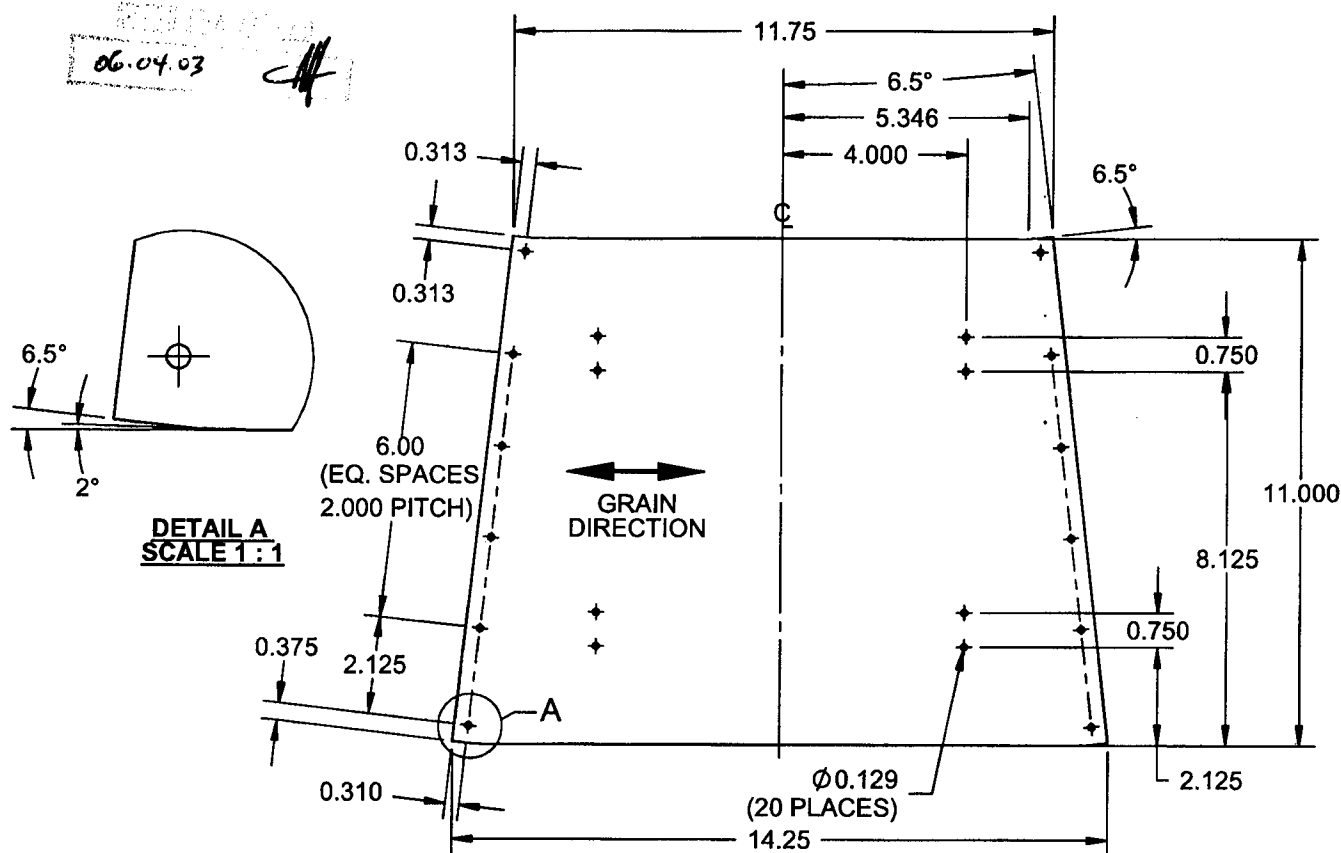
QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

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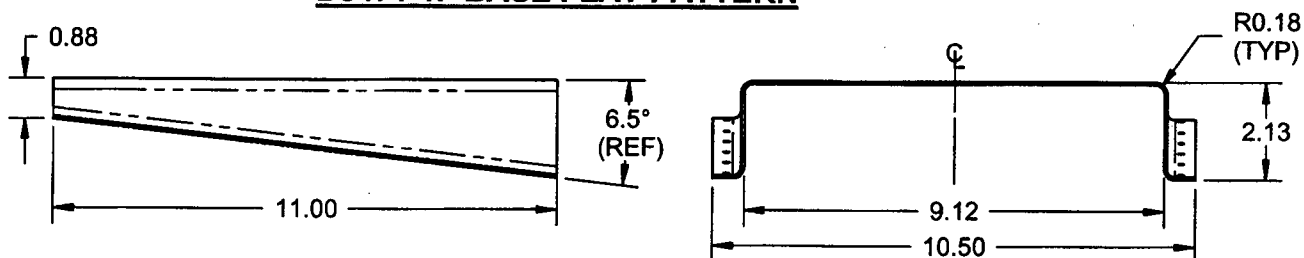
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:4



D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

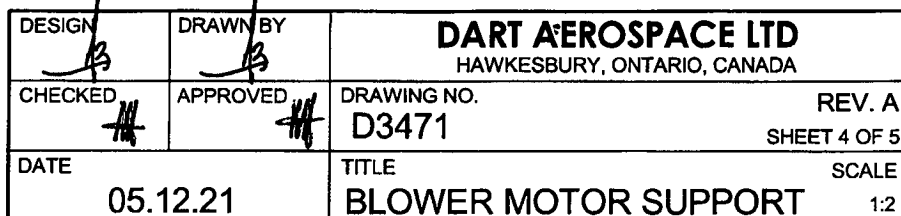
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

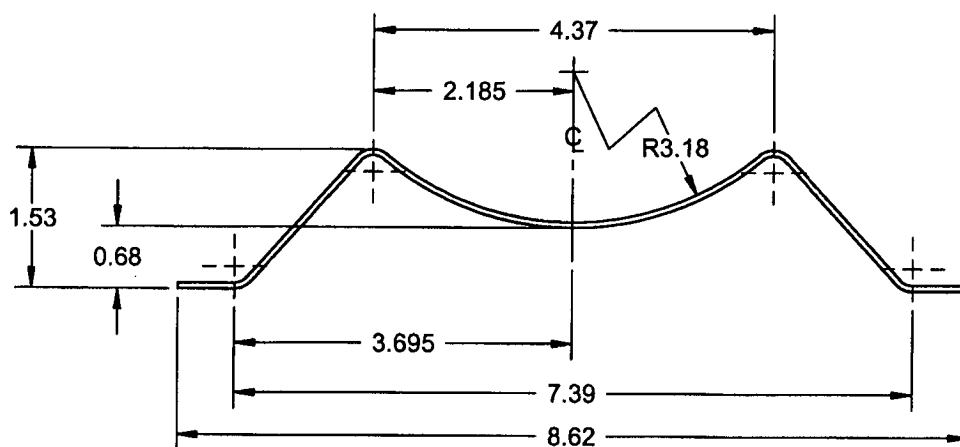
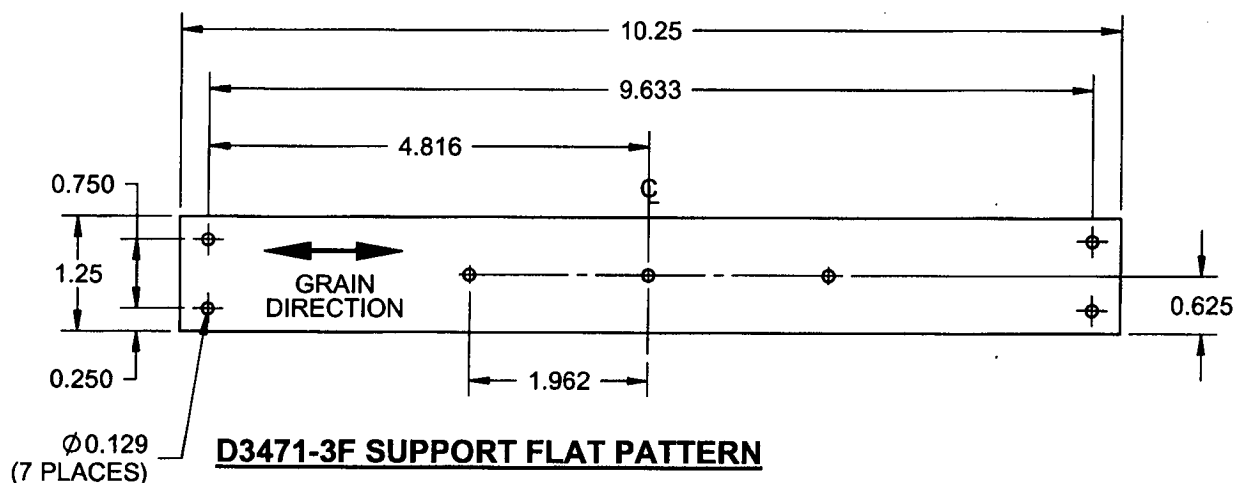
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06.04.03



D3471-3 SUPPORT BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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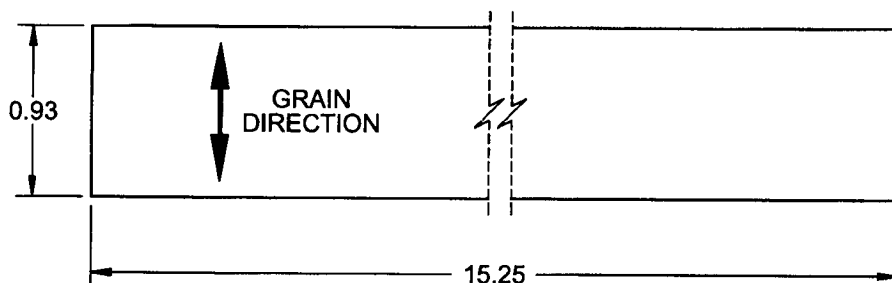
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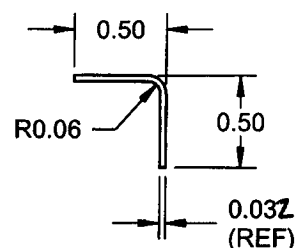


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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:1

06.04.03 *[Signature]*



D3471-5F STIFFENER FLAT PATTERN



**D3471-5 STIFFENER
BENDING DETAIL**

D3471-5 STIFFENER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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